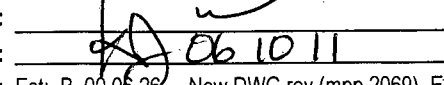
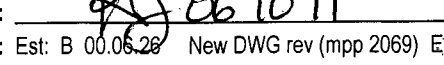


Date: Wednesday, 10/11/2006 12:50:01 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
<b>Job Number</b> : 28938	
<b>Estimate Number</b> : 10834	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D29332
<b>This Issue</b> : 10/11/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2933 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 28861	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 10/30/2006 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est: B 00.06.28 New DWG rev (mpp 2069) EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101001	7075-T7351 2X6X6.25
-----	----------	---------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Issue material from stock: 7075-T7351 QQ-A-250/12  
 Cut Size 2.0 x 6.25 X 6.00  
 Grain Along Long 6.00 Length  
 Batch No: B 25343

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet  
 5-Deburr

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



**Comment:** INSPECT ALL DIM TO DIM SHEET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 06/10/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 12:50:01 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 28938

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/10/14 x 6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*Handwritten signature*

06/10/14 x 6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 10 17 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*Handwritten signature* (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*Handwritten signature* (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten signature* (6)  
06/10/19

Job Completion



u 06/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>28938</b>
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	<b>D2933-2</b>
<b>Inspection Dwg:</b> D2933 Rev. B		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	.124	.124	.124		
B	0.100	0.140		.124	.123	.124	.124		
C	0.100	0.140		.123	.123	.125	.123		
D	0.210	0.230		.2205	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.499	2.499		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.122	.122	.122	.122		
O	0.540	0.560		.550	.549	.550	.549		
P	0.490	0.510		.499	.500	.498	.497		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.251	.250	.251	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.315	.319	.315	.315		
X	1.125	1.145		1.134	1.133	1.1335	1.134		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06.10.13

Audited by:	En
Date:	06/10/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

OBIESH LIG

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>28938</b>
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	<b>D2933-2</b>
<b>Inspection Dwg:</b> D2933 Rev. B		<b>Page 1 of 1</b>

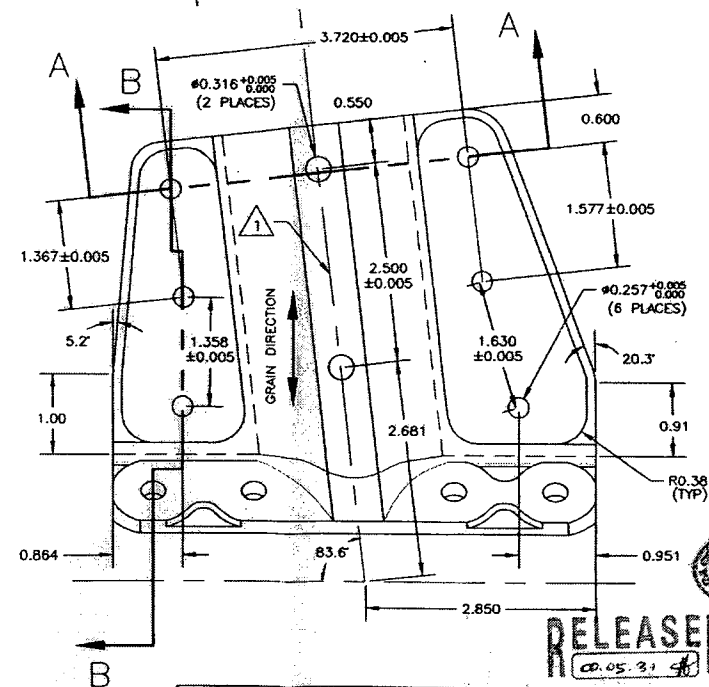
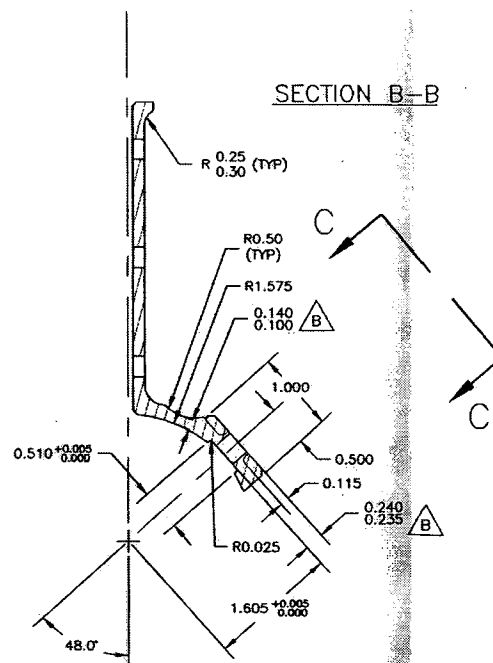
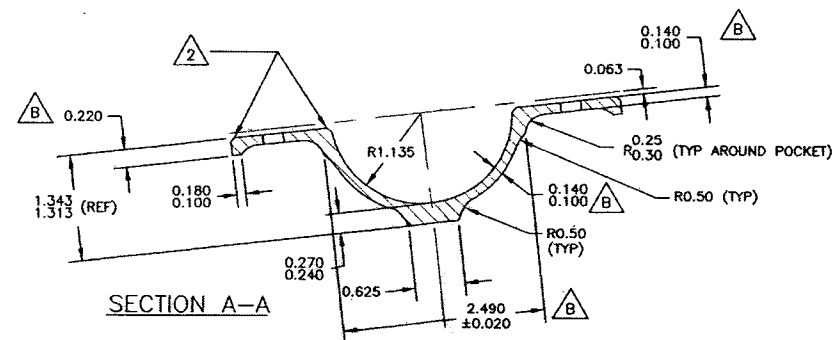
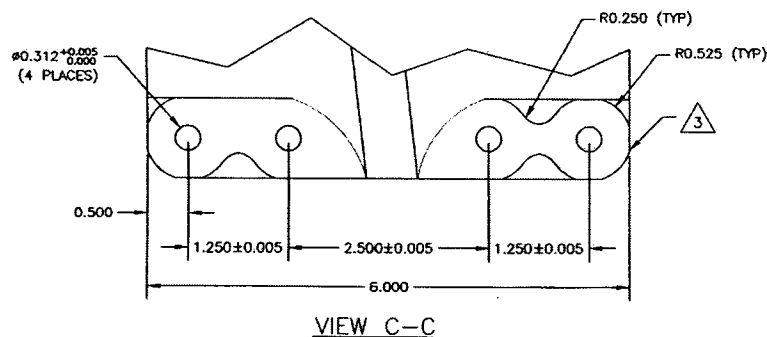
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.124	.124				
B	0.100	0.140		.124	.124				
C	0.100	0.140		.122	.123				
D	0.210	0.230		.220	.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.514	.514				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262	DT8683	.258	.258				
L	0.312	0.317	DT8686	.314	.314				
M	0.235	0.240		.237	.237				
N	0.100	0.140		.122	.123				
O	0.540	0.560		.550	.549				
P	0.490	0.510		.498	.496				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.492	2.492				
S	0.240	0.270		.251	.252				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	.315	.315				
X	1.125	1.145		1.134	1.134				
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06.10.13

Audited by:	En
Date:	06/10/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

MATERIAL: 7075-T7351 (QQ-A-250/12)  
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
 DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI-018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 28938

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 PERSON WITHOUT WRITTEN PERMISSION FROM  
 DART AEROSPACE USA, INC.

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BOLLEVILLE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	00.05.29	TITLE SADDLE INSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3

RELEASED  
 CD.05.31